

Work Order ID 81938

81938

Page 1


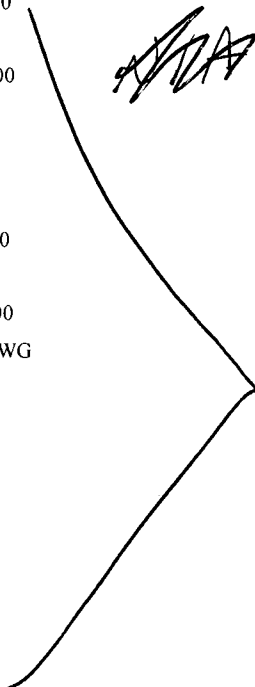
March-21-12 9:51:37 AM

Item ID: D4545-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Inner, RH (Side)
 Start Date: 21/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 04/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/21 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4545	B

100	Pick Kit	0.00	
100		0.00	
Packaging	Memo		
110		0.00	
110		0.00	
Small Fab	Memo		
Small Fab	1- ASSEMBLE AND BEND TABS AS PER DWG		
	2- TRANSFER DRILL HOLES AS PER DWG.		
	3- DISASSEMBLE AND DEBURR		
	4- DIMPLE HOLES AS PER DWG		

12/03/22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							12/03/22 SBR
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							2 H 123-22
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
140									
QC	Memo	0.00							2XPM 12/03/22
Quality Control									

PTO

Dart Aerospace Ltd

W/O: 81938		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
1203.22	145 + 146	Install nutplates before paint Permanent Change	DB	1203.22	2	DB G922	DB 1203.22	

Part No: D4545-044 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D4545-044 Accept ***N9000040100*** Setup Start ***NS1***
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 10h35 OVEN TEMPERATURE: 320°F FINISH TIME: 11h05	0.00 0.00 m15128.				2	2	2	12/03/23.
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	2	2	12-3-23
170 *170* Small Fab Small Fab	INSTALL NUT PLATES AS PER DWG Memo	0.00 0.00							12/03/22 (2)

W/O:		WORK ORDER CHANGES					
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Work Order ID 81938

March-21-12 9:51:37 AM

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Item ID: D4545-044

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Inner, RH (Side)

Start Date: 21/03/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Quality Control

Memo

0.00

12/03/22

SPR

190

Identify as per dwg & Stock Location: 442

0.00

190

Packaging

Packaging

Memo

0.00

12/3/23 50 (24)

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Quality Control

Memo

0.00

MLJ 12/03/26

MF

12-03-24

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Picklist Print

March-21-12 9:51:41 AM

Page 1

Work Order ID: 81938

81938

Parent Item: D4545-044

D4545-044

Parent Item Name: Retainer, Inner, RH (Side)

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM
REV:B 12.02.27 AS PER DWG REV.B DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-3 *D4541-3* Bracket		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2		B 81242	2		
					78276			2					
D4542-3 *D4542-3* Retainer, Inner		Manufactured	No			100	Each	2.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG				2		B 81267	2		
					78280			2					
MS20426AD3-4 *MS20426AD3-4* RIVET		Purchased	No			170	Each	3,914.000	28	56			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				3914					
					104374			1006			56		
					110398			2908					
MS21059L3K *MS21059L3K* Nutplate		Purchased	No			170	Each	0.0000	14	28			

M121114 (28)

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ITEM	QTY -041	QTY -042	QTY -043	QTY -044	QTY -045	QTY -046	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

~~8/1938~~ M.L.J
8/1938 12/02/21

PLEASE
2012-02-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.S.	DRAWING NO.	REV. B
MFG. APPR.	ES	D4545	SHEET 1 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	RETAINER, INNER	NTS
DATE	12.02.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

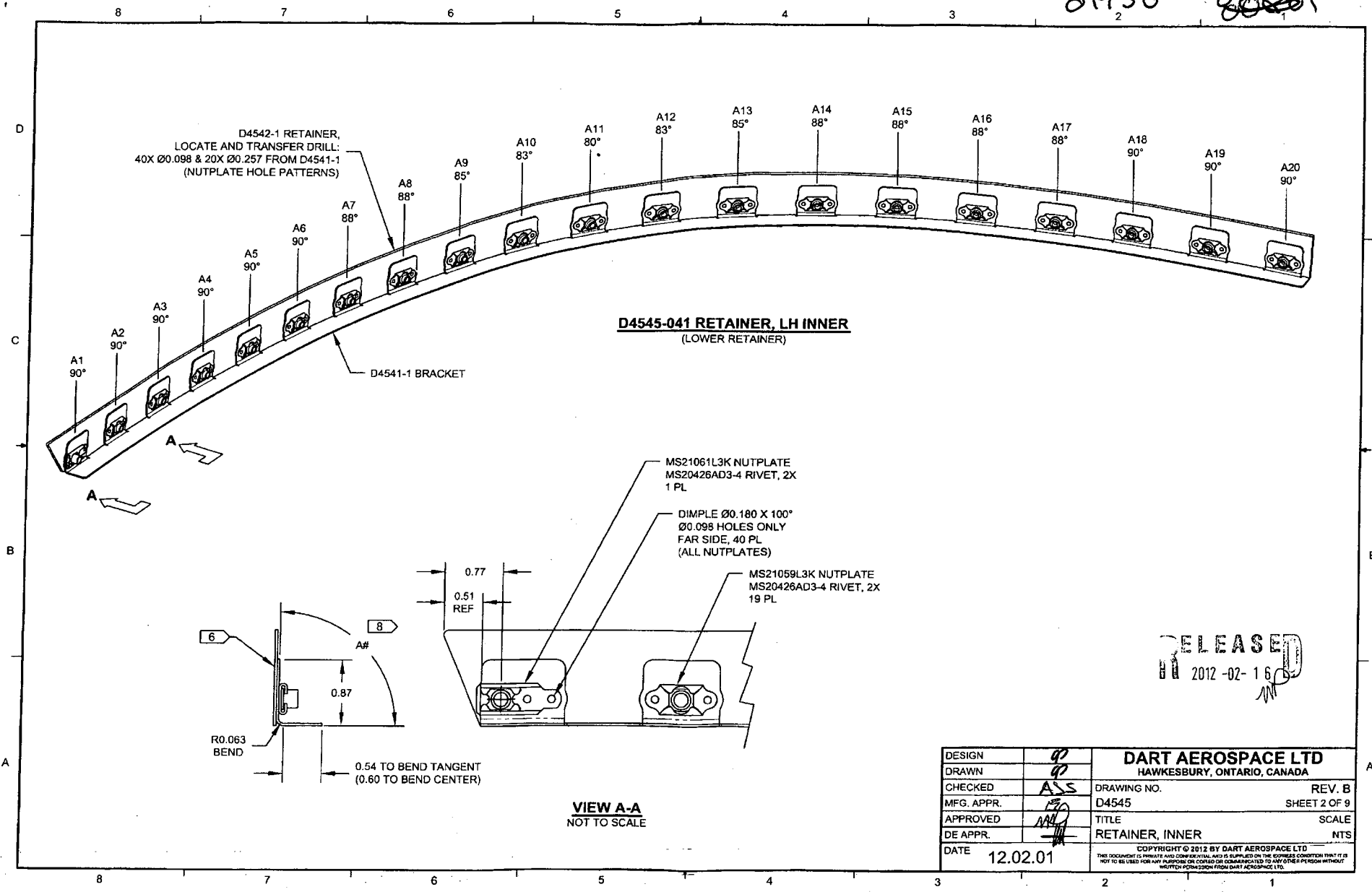
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81938

80001



RELEASED
2012-02-16

DESIGN	90	DART AEROSPACE LTD	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	10	D4545	SHEET 2 OF 9
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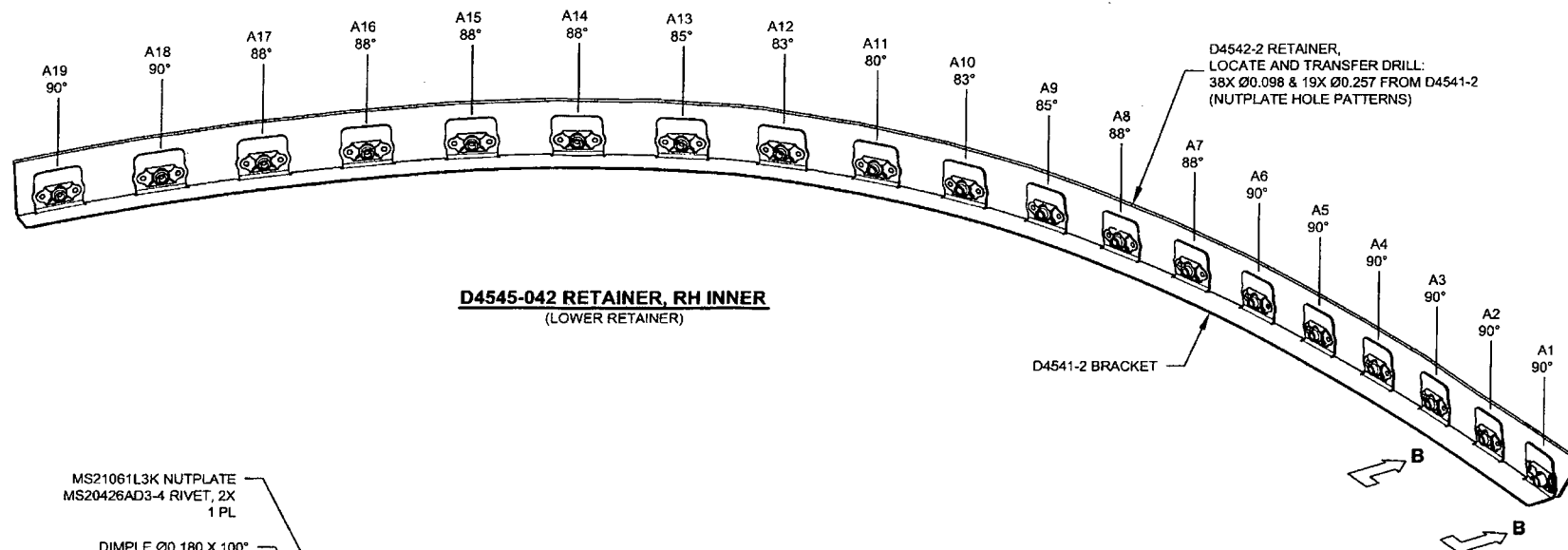
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8000 181938

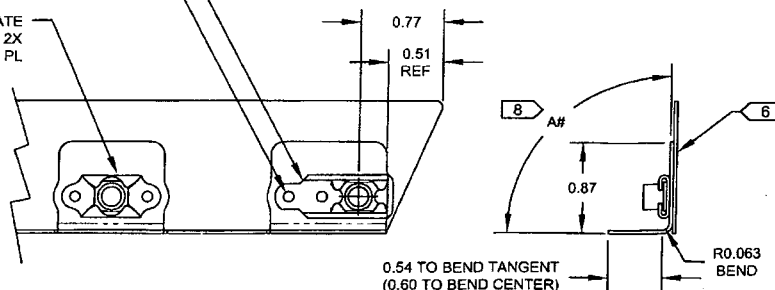


D4545-042 RETAINER, RH INNER
(LOWER RETAINER)

MS21061L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
1 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 38 PL
(ALL NUTPLATES)

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
18 PL



VIEW B-B
NOT TO SCALE

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2012-02-16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 3 OF 9
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8050x 81938

D4542-3 RETAINER,
LOCATE AND TRANSFER DRILL:
28X Ø0.098 & 14X Ø0.257 FROM D4541-3

D4545-043 RETAINER, LH INNER
(SIDE RETAINER)

D4541-3 BRACKET

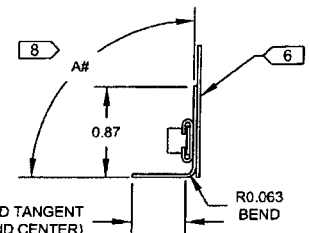
MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
14 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 28 PL

VIEW C-C
NOT TO SCALE

0.54 TO BEND TANGENT
(0.60 TO BEND CENTER)

RELEASED
2012-02-16
MD



DESIGN	90	DART AEROSPACE LTD
DRAWN	90	HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. B
MFG. APPR.	5	D4545 SHEET 4 OF 9
APPROVED	5	TITLE SCALE
DE APPR.	5	RETAINER, INNER NTS
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Dart Aerospace Ltd

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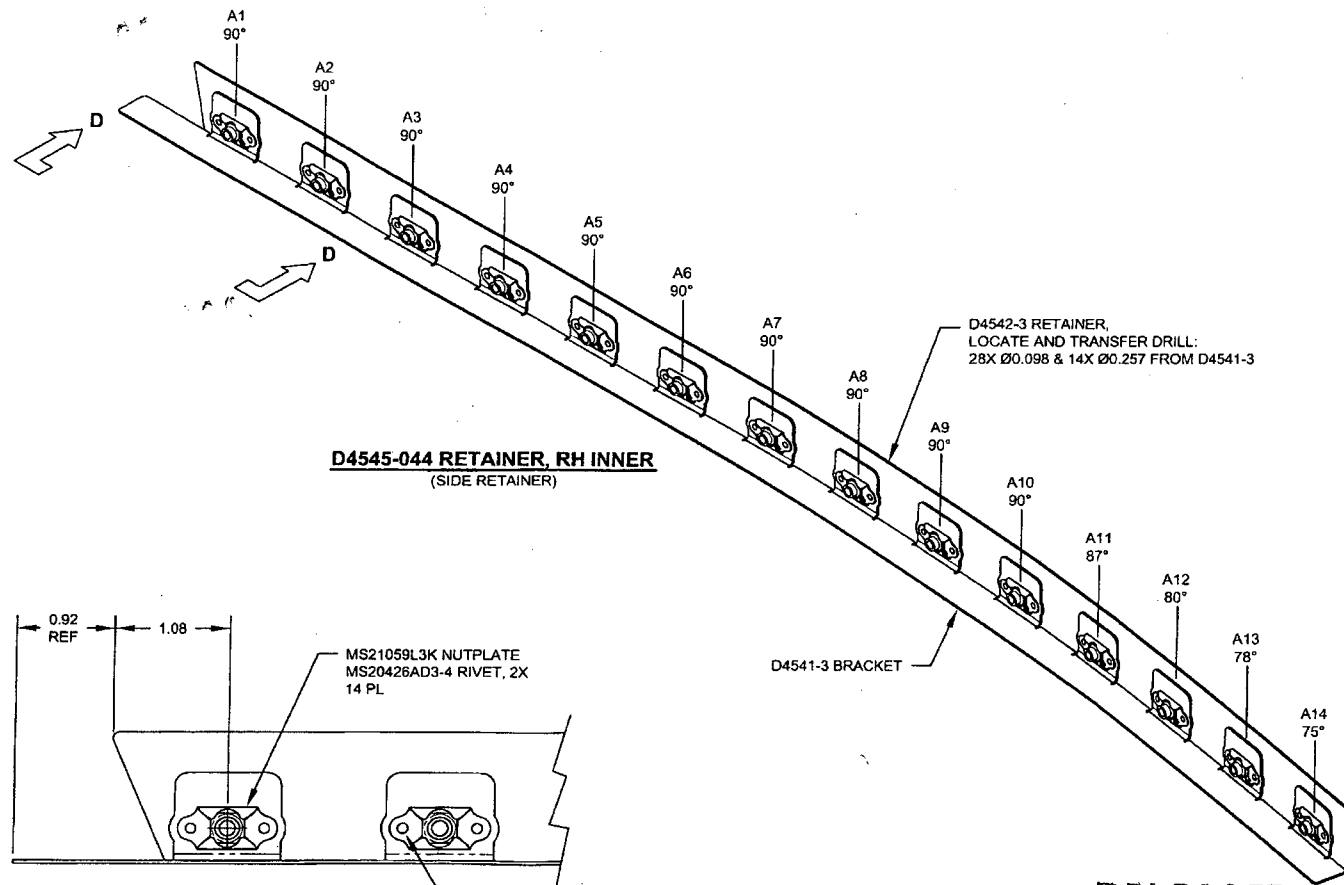
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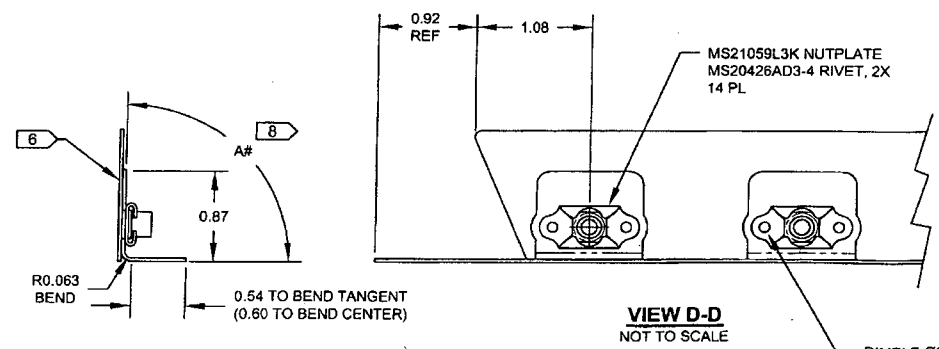
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D4545-044 RETAINER, RH INNER
(SIDE RETAINER)



VIEW D-D
NOT TO SCALE

RELEASED
2012-02-16

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MFG. APPR.		D4545	SHEET 5 OF 9
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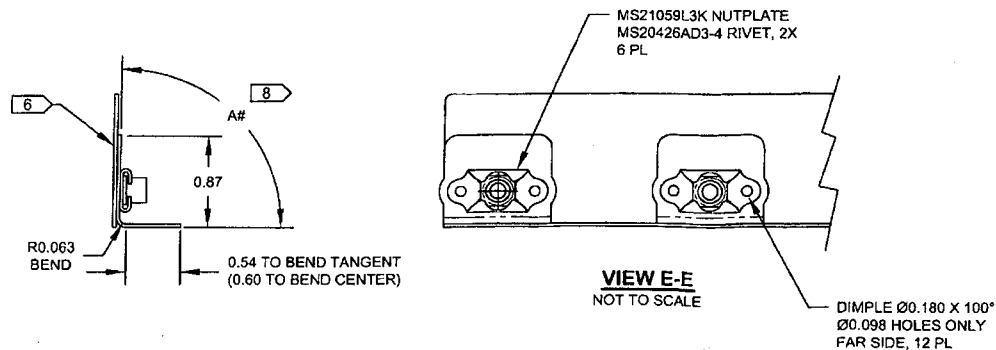
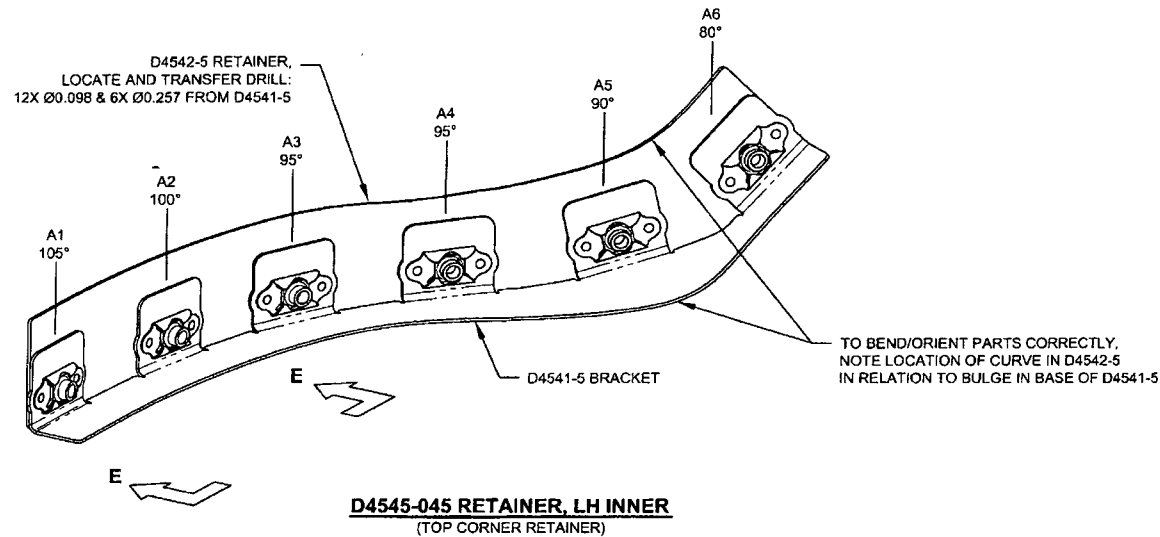
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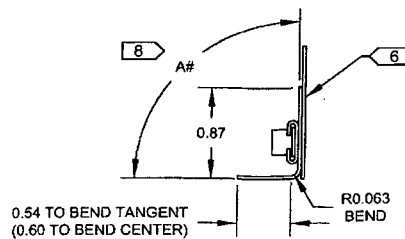
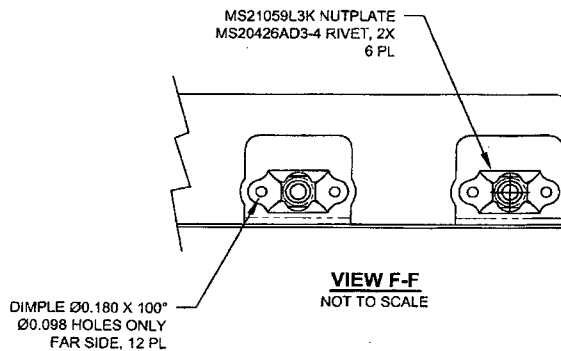
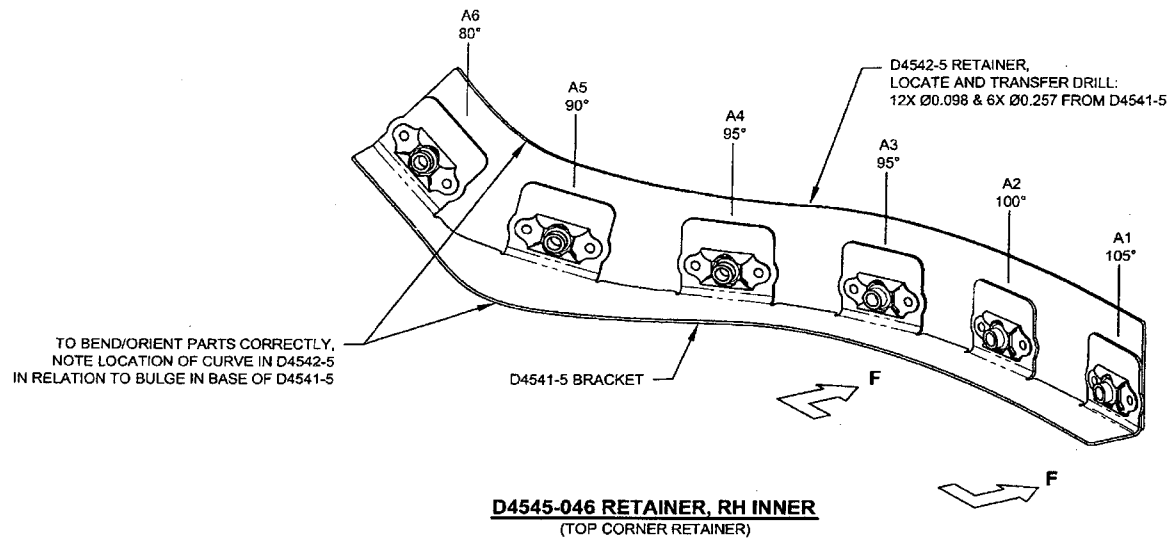
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~~80501~~ 81938



RELEASED
2012-02-16
WMP

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CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 7 OF 9
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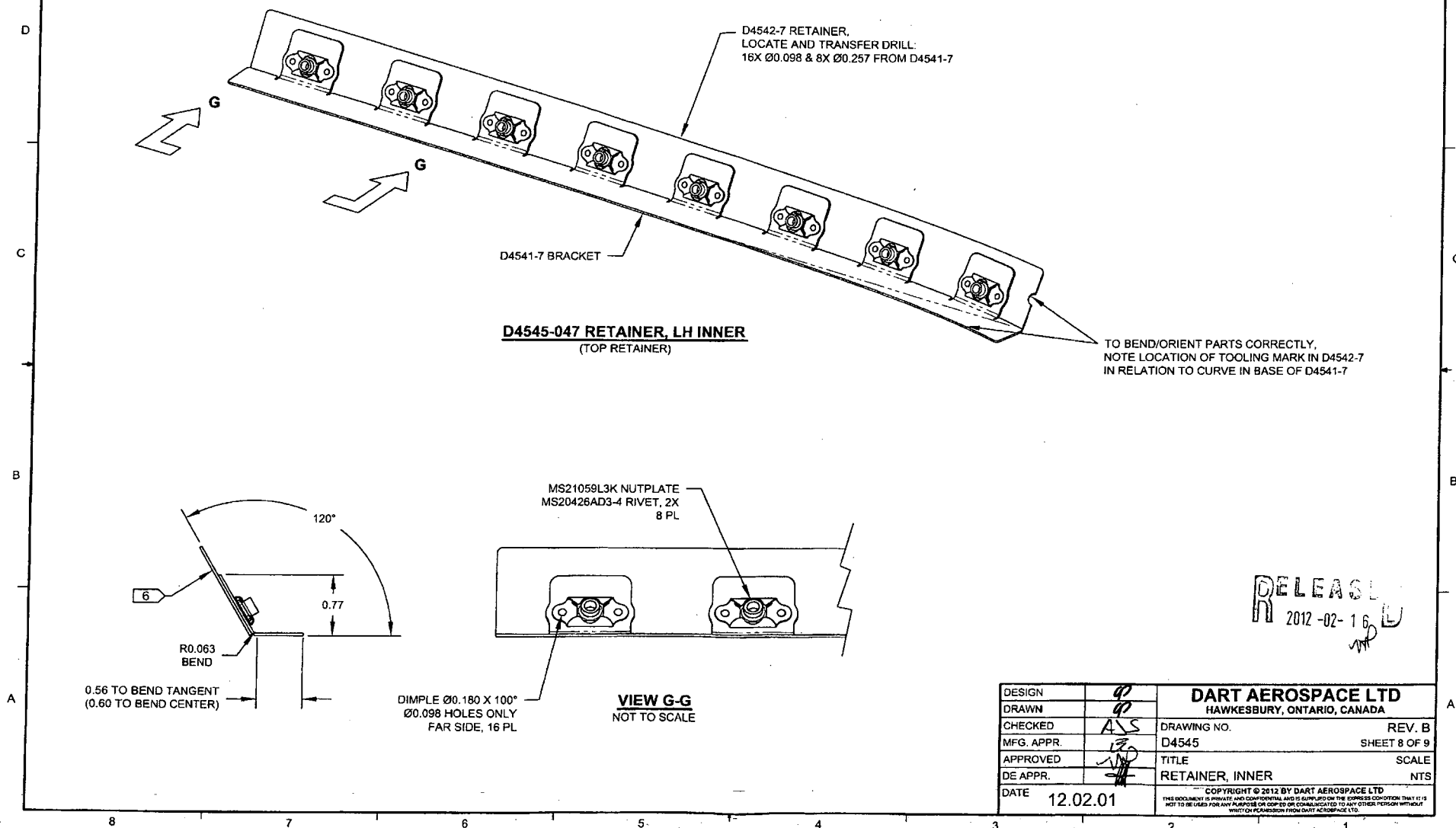
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81938



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

~~8050~~ 81938

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A

D4542-7 RETAINER,
LOCATE AND TRANSFER DRILL:
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

D4541-7 BRACKET

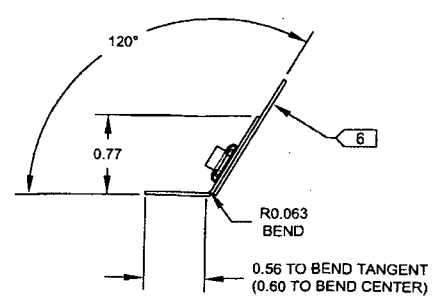
D4545-048 RETAINER, RH INNER
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,
NOTE LOCATION OF TOOLING MARK IN D4542-7
IN RELATION TO CURVE IN BASE OF D4541-7

MS21059L3K NUTPLATE
MS20426AD3-4 RIVET, 2X
8 PL

DIMPLE Ø0.180 X 100°
Ø0.098 HOLES ONLY
FAR SIDE, 16 PL

VIEW H-H
NOT TO SCALE



RELEASE
2012-02-16

DESIGN	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	90		
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	ED	D4545	SHEET 9 OF 9
APPROVED	MP	TITLE	SCALE
DE APPR.		RETAINER, INNER	NTS
DATE	12.02.01	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

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